








# Work Order ID 74649




Tuesday, October 04, 2011 3:20:04 PM



Page 1

Item ID: D2894-1 Accept  Setup Start   
Revision ID: Stop   
Item Name: 2.750 Support  
Start Date: 10/4/2011 Start Qty: 1.00  Cust Item ID:  
Required Date: 10/4/2011 Req'd Qty: 1.00  Customer:  
Reference: rework aog

Approvals: Process Plan: MF Date: 11-10-04 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

| Sequence ID/<br>Work Center ID   | Operation<br>Description                           | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| <b>Draw Nbr</b>  | <b>Revision Nbr</b>                                |                      |         |        |              |               |               |                  |                |
| D2894  | E  |                      |         |        |              |               |               |                  |                |
| 150  |  | 0.00                 |         |        |              |               |               |                  |                |
|    |  |                      |         |        |              |               |               |                  |                |
| Crosstubes   | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Crosstubes   | SUPPORTS NO LONGER HAVE ANY FINISH                 |                      |         |        |              |               |               |                  |                |
|  | -STRIP SUPPORT ASAP FOR AOG                        |                      |         |        |              |               |               |                  |                |
| 160  | QC5- Inspect part completeness to step on W/O      | 0.00                 |         |        |              |               |               |                  |                |
|  |  |                      |         |        |              |               |               |                  |                |
| QC   | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control  |  |                      |         |        |              |               |               |                  |                |
| 170  | Identify as per dwg & Stock Location: <u>LE 5A</u> | 0.00                 |         |        |              |               |               |                  |                |
|  |  |                      |         |        |              |               |               |                  |                |
| Packaging  | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Packaging  | ID AND STOCK UNDER NEW BATCH NUMBER                |                      |         |        |              |               |               |                  |                |

11 10 04 (1)

11-10-04 (1)

11-10-04 (1)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |






**NOTE:** Date & initial all entries



**Work Order ID 74649**

Tuesday, October 04, 2011 3:20:04 PM



Page 2

Item ID: D2894-1      Accept            Setup      Start        
Revision ID:      Stop        
Item Name: 2.750 Support  
Start Date: 10/4/2011      Start Qty: 1.00            Cust Item ID:  
Required Date: 10/4/2011      Req'd Qty: 1.00            Customer:  
Reference: rework aog

Approvals:      Process Plan: \_\_\_\_\_      Date: \_\_\_\_\_      Tooling: \_\_\_\_\_      Date: \_\_\_\_\_      Run      Start        
                 QC: \_\_\_\_\_      Date: \_\_\_\_\_      SPC (Y/N): \_\_\_\_\_      Date: \_\_\_\_\_      Stop      

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

180

QC21- Final Inspection - Work Order Release

0.00

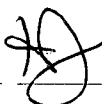


QC

Memo

0.00

Quality Control

11/10/04 me  
11-10-04

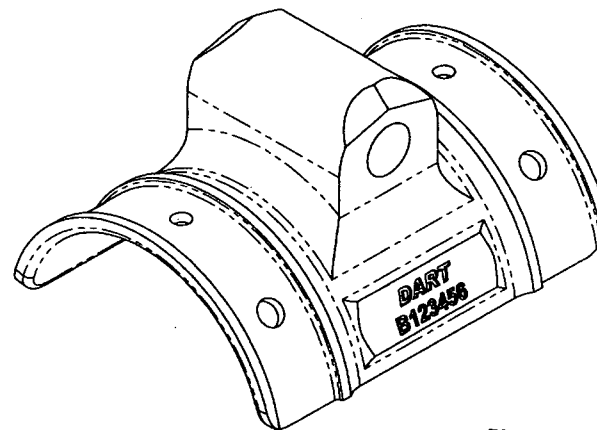
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



**D2894-1 Ø2.750 SUPPORT**

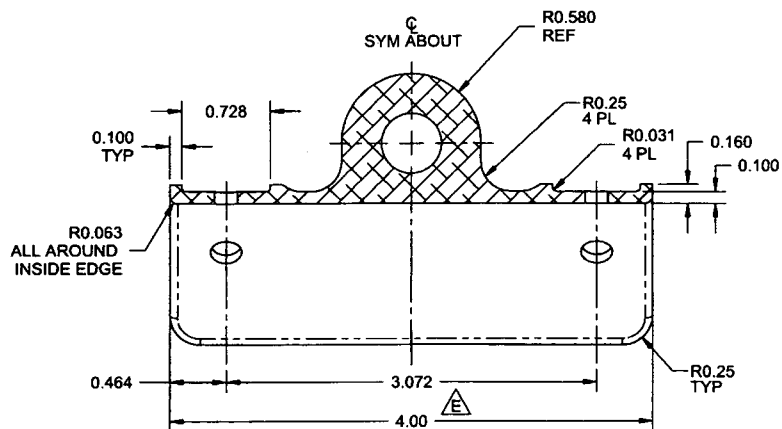
74649

**RELEASED**  
2011-09-29

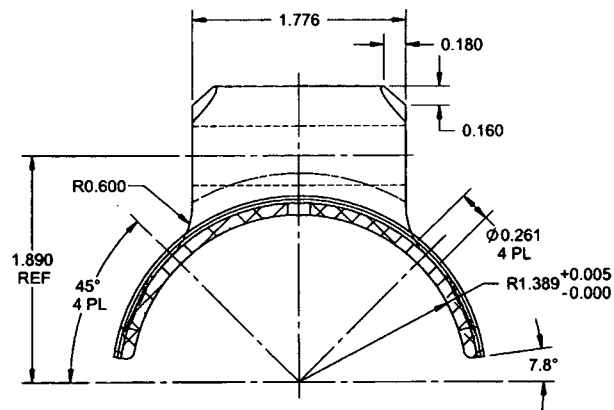
**NOTES:**

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION  
PER ASTM A564 OR AMS 5643 OR AISI 630  
MIN UTS = 170 KSI (38 HRc)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) 0.50" WIDE x 1.56" LONG x 0.005" MIN HEIGHT FLAT,  
WITH R0.25 RADIUS OF TRANSITION IN THIS AREA  
IDENTIFY WITH DART LOGO AND PART NUMBER ON ONE  
SIDE AND DART LOGO AND BATCH NUMBER ON OPPOSITE  
SIDE USING 0.010-0.020 DEEP LETTERING
- 7) WEIGHT: 0.98 lbs

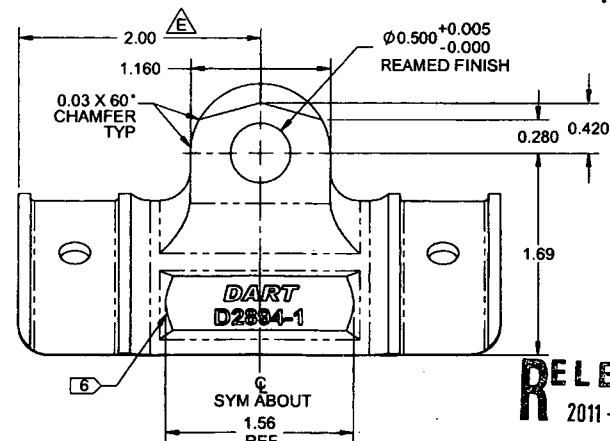
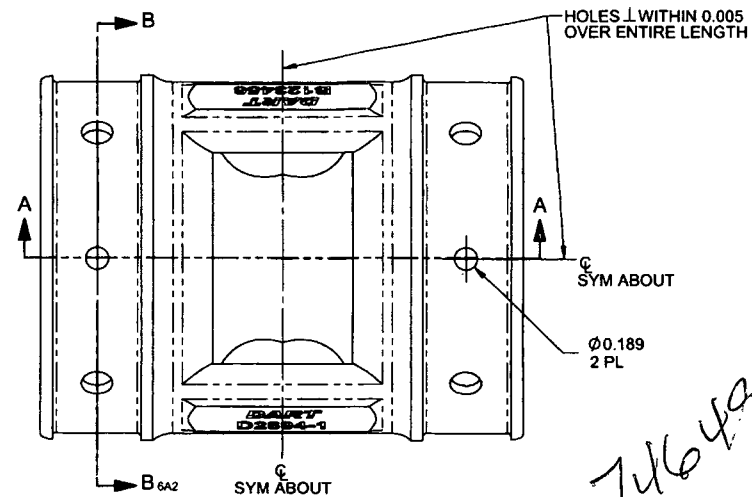
| E          | REMOVE PRIMER & UPDATE MAT'L SPEC (ZN A8-1), 2.00 WAS 2.000 (C3-2), 4.00 WAS 4.000 (C6-2), REF. CAR 11-51   | CP   | 11.09.07     |
|------------|---|--|--------------|
| D          | DRAWING REFORMATTED. POWDER COAT FINISH REMOVED. CHAMFERS ADDED TO TOP OF PART TO CLEAR ROCKER BEAM. PER BELL TECH BULLETIN 407-08-84, B5-2 0.261 HOLE WAS 0.257. B2-2 REAM FINISH INSTRUCTION ADDED. | AJS  | 08.11.06     |
| C          | ADD MASKING AND PRIME ONLY NOTES, REFORMATTED DRAWING.  | DC   | 07.07.04     |
| B          | AS MANUFACTURED   | CP   | 02.07.17     |
| A          | NEW ISSUE   | CP   | 02.04.02     |
| REV.       | DESCRIPTION   | BY   | DATE         |
| DESIGN     | CP  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | AS  |  |              |
| CHECKED    | AS  | DRAWING NO.  | REV. E       |
| MFG. APPR. | AS  | <b>D2894</b>   | SHEET 1 OF 2 |
| APPROVED   | AS  | TITLE  | SCALE        |
| DE APPR.   | AS  | <b>Ø2.750 SUPPORT</b>  | NTS          |
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SECTION A-A



SECTION B-B C3-2  
(VIEW ROTATED 90°)



D2894-1 Ø2.750 SUPPORT

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | CP       | DART AEROSPACE LTD   |              |
| DRAWN      | AS       | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | AS       | DRAWING NO. D2894  | REV. E       |
| MFG. APPR. | AS       |  | SHEET 2 OF 2 |
| APPROVED   | AS       | TITLE  | SCALE        |
| DE APPR.   | AS       | Ø2.750 SUPPORT   | NTS          |
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2011-09-29  
JWP